

Date: Monday, 7/9/2007 11:46:50 AM
 User: Kim Johnston

Process Sheet

⑥

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 33352		
Estimate Number	: 10832		
P.O. Number	: N/A	Part Number	: D29322
This Issue	: 7/9/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2932 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32378	Drawing Revision	: C
		Material	: N/A
		Due Date	: 7/30/2007
Written By	: <u>[Signature]</u>	Qty:	20 Um: Each
Checked & Approved By	: <u>[Signature] 07.07.09</u>		
Comment	: Est. B 60.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0 x 6.25 X 7.88
 Grain Along Long 7.88 Length
 Batch No: 139387

[Signature] 07/08/16 20

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 5-Deburr

[Signature] 07/08/16 20

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

[Signature] 07/08/16 20

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

[Signature] 07/08/16 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/08/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:46:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 33352

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07-08-17

(20)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR/M.K. 07-08-17

(20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068

BR/M.K. 07-08-20

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

2/8/21 SO LOT 107/07/21

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/08/21 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ED 07/08/22

(20)

Job Completion



U 07-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 33352
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.127	0.128		
B	0.100	0.140		0.127	0.127	0.127	0.127		
C	0.100	0.140		0.119	0.118	0.116	0.116		
D	0.210	0.230		0.225	0.224	0.226	0.225		
E	1.245	1.255		1.250	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.499	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.237	0.238	0.238		
N	0.100	0.140		0.119	0.120	0.122	0.122		
O	0.540	0.560		0.545	0.550	0.551	0.551		
P	0.490	0.510		0.500	0.500	0.500	0.502		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.490	2.492	2.492	2.492		
S	0.240	0.270		0.256	0.255	0.256	0.256		
T	0.100	0.180		0.136	0.140	0.138	0.140		
U	1.625	1.635		1.628	1.629	1.629	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.134	1.136	1.136	1.137		
Y	1.565	1.585		1.574	1.575	1.576	1.577		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Amk</i>
Date:	07/08/16

Audited by:	<i>SA</i>
Date:	07.08.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33352
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.127	0.128		
B	0.100	0.140		0.127	0.127	0.128	0.127		
C	0.100	0.140		0.116	0.115	0.117	0.116		
D	0.210	0.230		0.227	0.227	0.226	0.226		
E	1.245	1.255		1.249	1.250	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.499	2.499	2.500	2.500		
H	0.510	0.515		0.516	0.516	0.516	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.122	0.122	0.122	0.122		
O	0.540	0.560		0.551	0.551	0.551	0.551		
P	0.490	0.510		0.503	0.504	0.501	0.504		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.492	2.492	2.493	2.493		
S	0.240	0.270		0.257	0.255	0.255	0.255		
T	0.100	0.180		0.137	0.140	0.136	0.137		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.367	1.368		
W	0.316	0.321		0.326	0.320	0.320	0.320		
X	1.125	1.145		1.137	1.137	1.136	1.136		
Y	1.565	1.585		1.577	1.577	1.577	1.577		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	07/08/16

Audited by:	<i>SA</i>
Date:	01.08.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33352
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.128	0.127		
B	0.100	0.140		0.127	0.127	0.127	0.127		
C	0.100	0.140		0.116	0.116	0.117	0.115		
D	0.210	0.230		0.225	0.226	0.225	0.226		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.259	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.122	0.122	0.121	0.123		
O	0.540	0.560		0.552	0.552	0.551	0.552		
P	0.490	0.510		0.503	0.503	0.503	0.500		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.493	2.493	2.493	2.493		
S	0.240	0.270		0.257	0.255	0.256	0.256		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.629		
V	1.362	1.372		1.367	1.367	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.137	1.137	1.135	1.137		
Y	1.565	1.585		1.577	1.577	1.575	1.577		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>OML</i>
Date:	07/08/16

Audited by:	SA
Date:	01.08.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33352
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.127	0.127		
B	0.100	0.140		0.127	0.127	0.127	0.127		
C	0.100	0.140		0.117	0.117	0.118	0.117		
D	0.210	0.230		0.226	0.226	0.226	0.227		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.250	1.249	1.249		
G	2.495	2.505		2.506	2.506	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.576	1.576		
J	2.495	2.505		2.499	2.500	2.506	2.506		
K	0.257	0.262		0.259	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.122	0.122	0.122		
O	0.540	0.560		0.550	0.550	0.550	0.550		
P	0.490	0.510		0.503	0.502	0.502	0.501		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.494	2.492	2.492	2.492		
S	0.240	0.270		0.256	0.257	0.257	0.257		
T	0.100	0.180		0.136	0.138	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.367	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.136	1.135	1.136		
Y	1.565	1.585		1.575	1.575	1.576	1.578		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>MD</i>
Date:	02/08/16

Audited by:	<i>SA</i>
Date:	04.08.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33352
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.127	0.127		
B	0.100	0.140		0.128	0.127	0.128	0.127		
C	0.100	0.140		0.117	0.118	0.118	0.118		
D	0.210	0.230		0.226	0.226	0.225	0.225		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.499		
K	0.257	0.262		0.258	0.259	0.259	0.259		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.122	0.121	0.122	0.123		
O	0.540	0.560		0.551	0.550	0.550	0.551		
P	0.490	0.510		0.501	0.502	0.502	0.502		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		0.256	0.255	0.255	0.255		
T	0.100	0.180		0.138	0.136	0.136	0.137		
U	1.625	1.635		1.628	1.629	1.629	1.629		
V	1.362	1.372		1.366	1.366	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.136	1.136	1.137		
Y	1.565	1.585		1.575	1.576	1.576	1.577		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SW</i>
Date:	07/08/16

Audited by:	<i>SA</i>
Date:	07.08.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

